

SHR TODAY 05/68

Work Order ID 83972

83972

Item ID: D3189-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Chafing Shield

Start Date: 30/04/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 14/05/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/04/30

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3189

Rev B

100

0.00

100

SHEAR

Waterjet

Memo

0.00

FLOW CNC Waterjet

304 0.020

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

20 0

JM/MLJ
12-5-8

103

QC2- Inspect parts off machine FAI/FAIB

0.00

103

QC

Memo

0.00

Quality Control

20 0

JM/MLJ
12-5-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83972

83972

Page 2

April-30-12 2:37:28 PM

Item ID: D3189-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Chafing Shield

Start Date: 30/04/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 14/05/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

105

QC8- Inspect parts - second check

0.00

105

QC

Memo

0.00

Quality Control

110

Small Fab

0.00

110

Small Fab

Memo

0.00

Small Fab

1- Roll as per Dwg D3189

2- Apply a thin layer of Pro Seal on inside surface of chafing shield 0.03" - 0.06" thick as per DSI9549 and DEO D412-664-243.

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

cuttes
+20

SA 160509

20

AB 12-5-10 (20)

20

12 05 10

W/O:		WORK ORDER CHANGES					
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Work Order ID 83972

83972

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April-30-12 2:37:28 PM

Item ID: D3189-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Chafing Shield
 Start Date: 30/04/2012 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 14/05/2012 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <i>l-tubes</i> <i>Assy</i> Memo	0.00 0.00				<i>(20)</i>			<i>W/W 12-05-10</i>
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>MLJ 12/05/10</i> <i>MLF 12-05-10</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April-30-12 2:37:33 PM

Page 1

Work Order ID: 83972

83972

Parent Item: D3189-1

D3189-1

Parent Item Name: Chafing Shield

Start Date: 30/04/2012

Required Date: 14/05/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP B05.08.22 No longer made in-house KJ/JLM

IPP Rev: C 06-03-24 Rolling Now made in House JLM

IPP Rev: D 07-04-16 As per Rev B JLM

IPP Rev: E

11.05.11 now made on waterjet DD verf: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA		Purchased	No			100	sf	85.0000	0.32	6.736842			

M304S25GA

304/316 .020" Sheet

Location

Loc Qty

Loc Code

MAT020

85

118228

85

118228

6.7

Jm/wh
12-5-8

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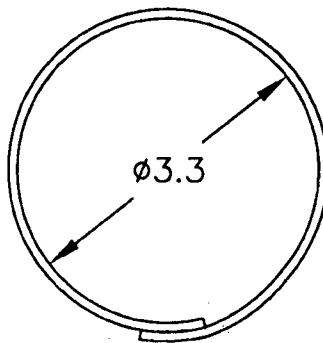
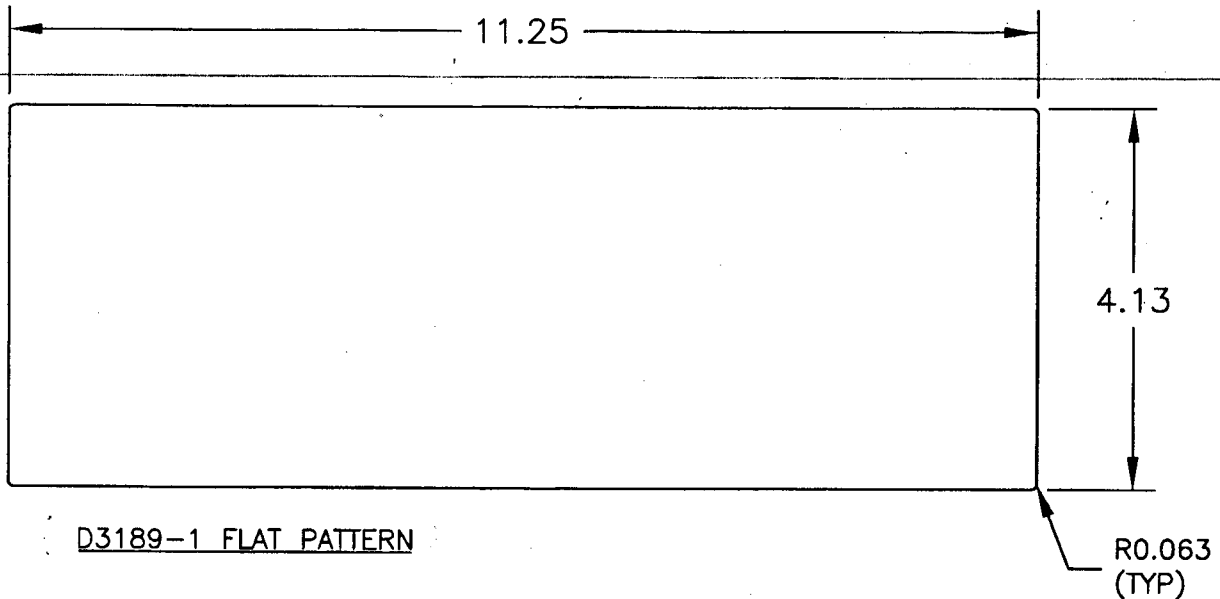
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NOTE: Date & initial all entries

DART

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3189	REV. B SHEET 1 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.08	NEW ISSUE	
B	07.01.05	ADD -3	

RELEASED07.03.27 *[Signature]*

D3189-1 ROLLING DETAIL
NOT TO SCALE

D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *83972*

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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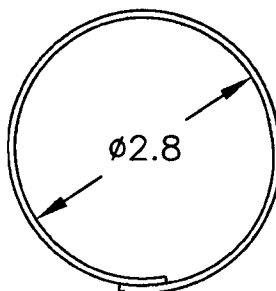
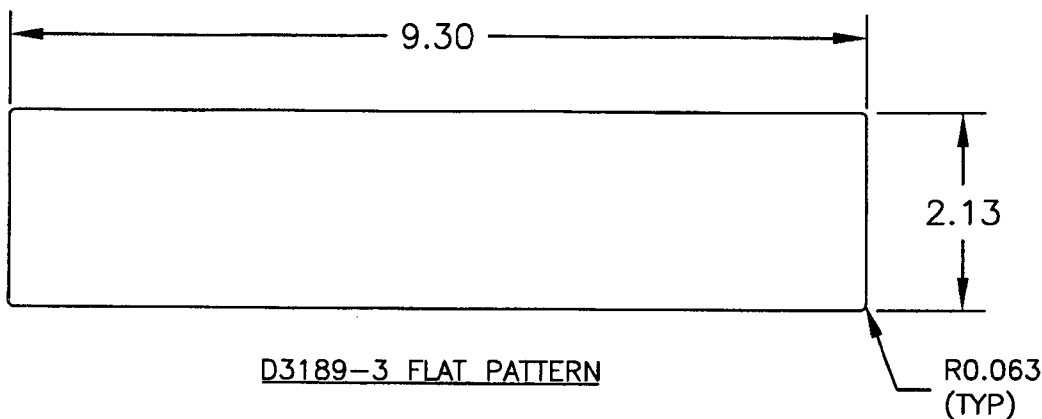
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DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3189	REV. B SHEET 2 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2

RELEASED
07.03.27 *[initials]*



D3189-3 ROLLING DETAIL
NOT TO SCALE

D3189-3 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

83972

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